

# Work Order ID 76865

**\*76865\***

Page 1

November-22-11 10:57:47 AM

Item ID: D2512 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Basket Lid 205/350  
 Start Date: 22/11/2011 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 30/11/2011 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: M.C.J Date: 11/11/22 Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2512	Rev E

100 Weld per dwg A/R S.S. rod Batch: M117884 0.00  
**\*100\*** Large Fab  
 Memo 0.00  
 1-Cut 3/4" x 3/4" square tubing as per Dwg D2512  
 2-Cut (4) D2236 From D3166-3  
 3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305  
 4-Weld as per Dwg D2512 using Welding Jig DT 9436  
 Deburr as required  
 \*\*\*INSTALL D2012-117 CLEVIS ONLY ON D130-701-041\*\*\*

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00  
**\*110\*** QC Memo 0.00  
 Quality Control

*Handwritten notes:*  
 12.02.07 1x  
 BE 12.02.07 1 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 76865****\*76865\***

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Item ID: D2512

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Basket Lid 205/350

Stop **\*NS2\***

Start Date: 22/11/2011 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 30/11/2011 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC6- Inspect dimensions to drawing

0.00

**\*120\***

QC

Memo

0.00

Quality Control

125

Pressure Wash per QSI005 4.3

0.00

**\*125\***

HandFinish

Memo

0.00

Hand Finishing

1X Ø m-l 12/02/17

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Revision ID:

Stop **\*NS2\***

Item Name: Basket Lid 205/350

Start Date: 22/11/2011 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 30/11/2011 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

**\*130\***

Powdercoat

Powder Coating

Memo

0.00

1- Plug holes in D2581 and in D2327-1 bushing prior to Powdercoat

1ST COAT:

START TIME: 10:50OVEN TEMPERATURE: 400°FFINISH TIME: 11:20

2ND COAT:

START TIME: \_\_\_\_\_

OVEN TEMPERATURE: \_\_\_\_\_

FINISH TIME: \_\_\_\_\_

*1 XPM / 12/02/17*

140

HandFinishing

0.00

**\*140\***

HandFinish

Hand Finishing

Memo

0.00

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4

Batch: 10073*1 BK 12.2.23.**M119480*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Item Name: Basket Lid 205/350

Start Date: 22/11/2011 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 30/11/2011 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start **\*NR1\***

QC: Date: SPC (Y/N): Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150 QC3- Inspect Part Finish

0.00

**\*150\***

QC Memo

0.00

Quality Control

1  $\phi$  M 12/02/23160 Identify as per dwg & Stock Location: **035-007041****\*160\***

Packaging Memo

0.00

Packaging

PP 76845

1 BL 12.23

170 QC21- Final Inspection - Work Order Release

0.00

**\*170\***

QC Memo

0.00

Quality Control

MLJ 12/02/24

12-02-24  
C

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

November-22-11 10:57:51 AM

Page 1

Work Order ID: 76865

\*76865\*

Parent Item: D2512

\*D2512\*

Parent Item Name: Basket Lid 205/350

Start Date: 22/11/2011

Required Date: 30/11/2011

Start Qty: 1.00

Required Qty: 1.00

## Comments:

Rev IPP:M03.01.31 AddedD2012-117forD130-701-041KJ/RF  
 IPP Rev:N06.04.05 Added level21 EC  
 IPP REV:O ADDED D3490-1/-3 FOR D130-701-011/-043 10-04-20 JLM  
 VERIFIED BY:DD  
 IPP Rev:P 08-08-29 revE as per dwg DD verified by:EC  
 IPP Rev:Q 08-09-24 plug holes prior to powder coating DD verified  
 by:EC IPP Rev:R  
 10.06.29 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2012-117		Manufactured	No			100	Each	35.0000	2	2			
<b>*D2012-117*</b>													

Clevis

*Handwritten signature*

*lpc 12.02.24*

Location	Loc Qty	Loc Code
WA	31	
69890	31	
WA005	4	
55729	4	

\*\*\* ONLY APPLICABLE ON D130-701-041-IF  
 NOT USED, PLEASE MARK N/A \*\*\*

D2232-1		Manufactured	No			100	Each	2.0000	2	2			
<b>*D2232-1*</b>													

Basket Hinge

Location	Loc Qty	Loc Code
WA	2	
70842	2	

*Handwritten: 879472 -> (2)*

D2327-1		Manufactured	No			100	Each	41.0000	2	2			
<b>*D2327-1*</b>													

Spacer Bushing

Location	Loc Qty	Loc Code
WA	41	
69728	15	
73692	26	

*Handwritten: (2)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 2

Work Order ID: 76865

\*76865\*

Parent Item: D2512

\*D2512\*

Parent Item Name: Basket Lid 205/350

Start Date: 22/11/2011

Required Date: 30/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2506 Manufactured No

100 Each 11.0000 1 1

\*D2506\*

Label Plate

\*\*

*Pl 12.06*

Location

Loc Qty

Loc Code

WA

11

71087

1

74142

10

D2581 Manufactured No

100 Each 40.0000 2 2

\*D2581\*

Mounting Bracket

\*\*

*Pl 12.03.02*

Location

Loc Qty

Loc Code

WA

40

69739

2

70766

2

73762

11

75280

25

D3166-3 Manufactured No

100 Each 6.0727 1 1

\*D3166-3\*

Basket Hoop

\*\*

*Pl 12.03.02*

Location

Loc Qty

Loc Code

WA

6

73627

6

WA007

0.07270527

64928

0.02010527

68442

0.0526

*B77294* → *①*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

Work Order ID: 76865

Parent Item: D2512

Parent Item Name: Basket Lid 205/350

\*76865\*

\*D2512\*

Start Date: 22/11/2011

Required Date: 30/11/2011

Start Qty: 1.00

Required Qty: 1.00

M304EX0.75-16F

Purchased

No

100

sf

554.2561

18

18.94737

\*M304EX0 75-16F\*

Expanded Metal Flat SS

\*\*

Pl 12.02.06

Location

Loc Qty

Loc Code

WA

554.2561116

117197

102.9036

117896

53.3264

118153

76.8473

118248

33.0983

118597

21.06788

118955

82.17

119180

184.842632

M120153 → 18.94737

M304TS0.750W.065

Purchased

No

100

f

506.7499

43.5804

45.87411

\*M304TS0 750W 065\*

304 SQ Tube .75x.75x.065W

\*\*

Pl 12.02.02

Location

Loc Qty

Loc Code

MAT018

485.0857585

117636

67.9987

118773

417.087059

WA

6.0667

118181

6.0667

WA007

15.5974906

116267

14.628472

116763

0.9690186

45.87411

November-22-11 10:57:51 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

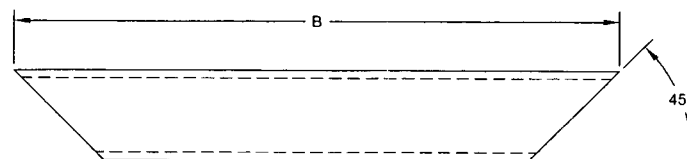
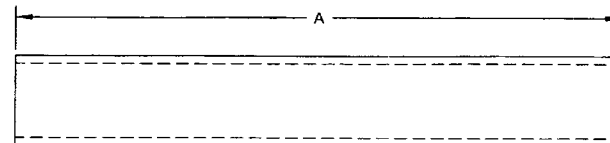
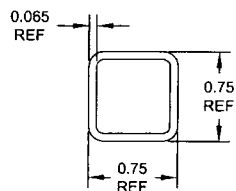
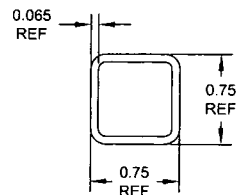
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**NOTE:** Date & initial all entries

# **PARTS LIST FOR D2512 BASKET LID ASSEMBLY**

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRACKET

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO APPROVAL  
WITHOUT NOTICE  
WORK ORDER  
NO. 76865 M.C.J  
11/11/22



**RELEASED**  
08-08-21-117

E	INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3 ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERRED TO "B" FORMAT AND UPADTED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	COPYRIGHT © 1995 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

## **D2512-1/-3/-5/-7 NOTES:**

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING  
REF. DART SPEC M304TS0.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

W/O:		WORK ORDER CHANGES					
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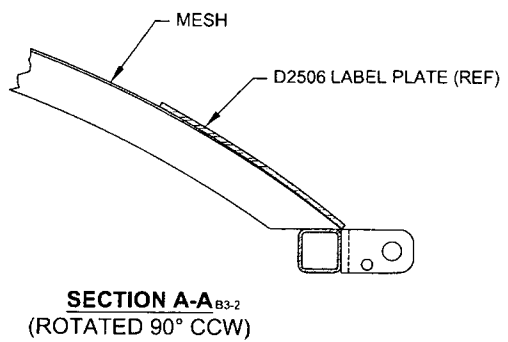
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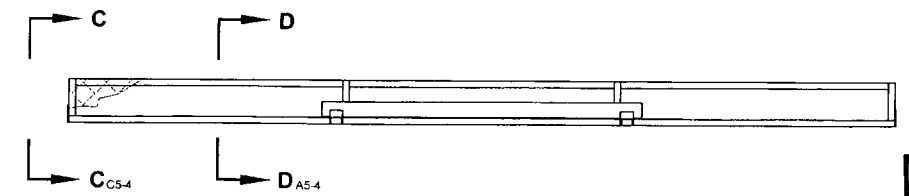
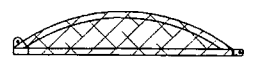
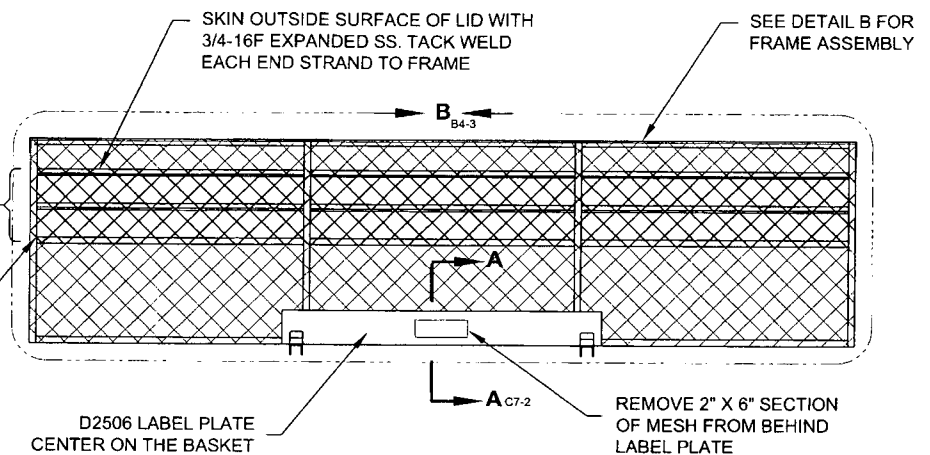


76865



FINISH THIS SECTION ALONG  
ENTIRE LENGTH PER NOTE 3  
AFTER POWDER COAT.

TACK WELD MESH TO FRAME  
AT EVERY AVAILABLE LOCATION  
IN AREA TO BE ANTI-SKIDDED



- D2512 BASKET LID ASSEMBLY NOTES:**
- 1) MESH MATERIAL: 3/4-16F EXPANDED SS  
REF DART SPEC M304EX0.75-16F
  - 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
  - 3) SPRAY PAINT BLACK INSIDE SURFACE  
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
  - 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 6) BREAK SHARP EDGES: N/A
  - 7) IDENTIFICATION: NONE
  - 8) WEIGHT: N/A
  - 9) WELD PER DART QSI 004

**RELEASED**  
08.06.17

DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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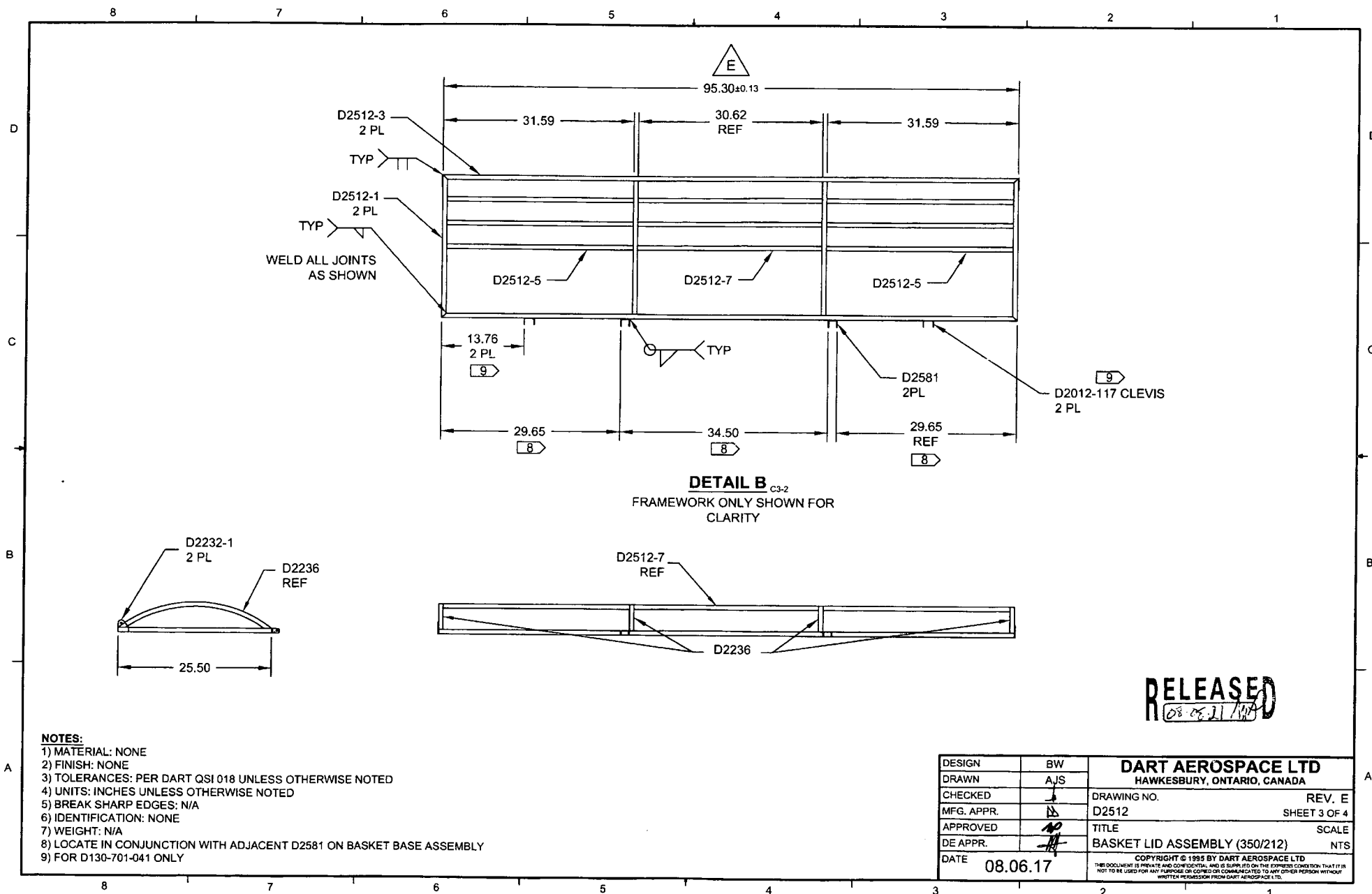
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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76065



RELEASED  
08-06-21/1980

W/O:		WORK ORDER CHANGES					
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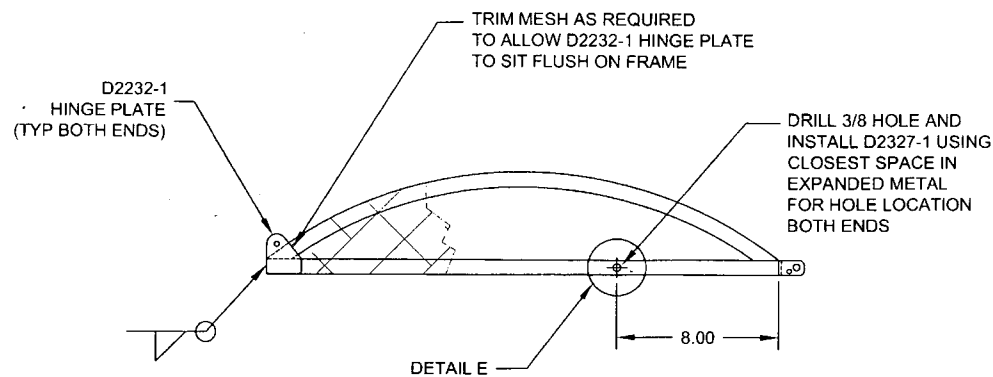
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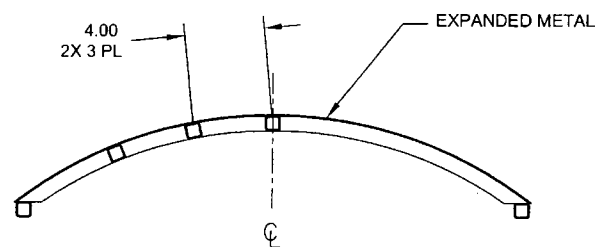
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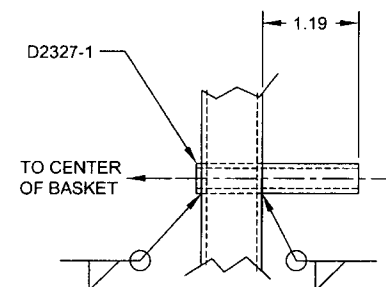
8 7 6 5 4 3 2 1



**VIEW C-C SIMILAR BOTH END RIBS** A5-2



**SECTION D-D SAME BOTH CENTER RIBS** A4-2



**DETAIL E** C6-4

**RELEASED**  
08-06-17

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries